Dart Aerospace Ltd. Thursday, 10/11/2007 2:54:51 PM Kim Johnston User **Process Sheet Drawing Name** : BUSHING Customer : CU-DAR001 Dart Helicopters Services Job Number : 35130 : 10175 **Estimate Number** : D2570 : N)A **Part Number** P.O. Number S.O. No. : MA D2570 REV B 10/11/2007 **Drawing Number** This Issue : N/A Project Number Prsht Rev. : MACHINED PARTS Type **Drawing Revision** First Issue : 34811 Previous Run Material **Due Date** : 11/10/2007 Qty: 500 Um: Each Written By Checked & Approved By Re-format; Removed finishing; Material changeK : Est .08.29 Comment J est F 07.07.06 rev B dwg EC **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: M303R0750 303 Round Bar .75" 1.0 37.5' 40.4775 f(s) Comment: Qty.: 0.0810 f(s)/Unit Total: Material: Ø0.750 AISI 303 SS Rod (M303R0.750) 765801 34.35 2.0 Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 Comment: SECOND CHECK PACKAGING 1 PACKAGING RESOURCE 5.0

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 34

A/N/26 59



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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5 (1)					1		21.101

Part No: _	PAR #:	Fault Category:	NCR: Yes No DQA:	Date: 0/10/07
			QA: N/C Closed:	Date:

		WORK ORDI	ER NON-CONFORMANC	E (NCR)						
	Description of NC		Corrective Action Section B		Varification	A				
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Corrective Action Section B Sign & Date Initial Chief Eng Chief	STEP Section A Initial Chief Eng Chief Eng Chief Eng Sign & Date Verification Section C	STEP Description of NC Section A Description Chief Eng C			

NOTE: Date & initial all entries

Date:

Thursday, 10/11/2007 2:54:52 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 35130

Part Number: D2570

Job Number:



Seq. #:

Job Completion

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



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W/O:		WOR	K ORDER CHANGES				
DATE	STEP	PROCEDURE CHANG	ВЕ Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #: Fault Catego	NCP: Vos	No DQ	A -	Date:	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Annessal	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35130	
Description: Bushing	Part Number:	D2570	
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

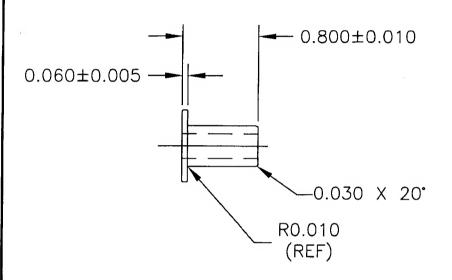
Drawing	T-1-	Actual	A	Dalland	Method of	0
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.800	+/-0.010	0.801				
0.060	+/-0.005	0.059				
R0.010	+0.010/-0.000	0.015	<u> </u>			
Ø0.425	+0.000/-0.002	0.4235			7	
Ø0.257	+0.005/-0.000	0,2575	_/_			
Ø0.750	+/-0.010	0.745				
0.030 x 20°	+/-0.010	0.02 x28				
				20		
		,				
				:		

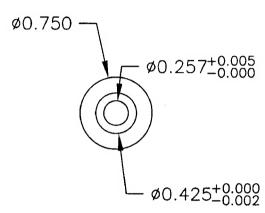
Measured by:	Audited by: 5.	Prototype Approval:	N/A
Date: 07 (10/23	Date: 04/10/23	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	B
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DESIG	PH	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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	世	H	D2570 SHEET 1 0	F 1
DATE			TITLE SC.	ALE
07.0)4.17		BUSHING	1:1
Α		96.09.16	NEW ISSUE	
В		07.04.17	UPDATE NOTES	





D2570 BUSHING

D2570 BUSHING

1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

. 2 :

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